Work Order ID 96191-

January-24-13 7:59:05 AM

HAAS I

HAAS CNC vertical machine #1

96191

Page 1

Item ID: D2360 Accept *N900040100* Setup Start Revision ID: Litter Tie Down Assembly Item Name: 1/21/13 Start Date: Start Qty: 4 Cust Item ID: Required Date: 2/06/13 Reg'd Qty: 4.00 Customer: Reference: Run Start Process Plan: MLJ Date: 13-01-25 Tooling: Approvals: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Reject Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr Revision Nbr D2341 Rev F D2360 Rev D 100 0.00 BAND SAW 10 *100* 13/02/15 Bandsaw 0.00 Memo Cut blanks: 12.65" Long Jeaspa Bandsaw 110 0.00 HAAS CNC VERTICAL MACHINING #1 *110* 0 Fit 13/02/22 JFC/b. 2013-02-23 10

0.00

Memo

2-Deburr

Machine as per Folio D2341 and Dwg D2341

											DQA:	D	ate:	
NCR:	Yes / N	lo			WORK ORDER NON-O	100	NFORI\	ANCE / UPD	ATE					
					r	_				(QA Closed:	D	ate:	
Work Orde	ar.				DISPOSITION				AGAINST D	EP	ARTMENT/	PROCESS		
WOIK OIG					Rework	1		Skid-tube	Crosstube			Water Je	t 🗍	Engineering
Part N	No.				Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor		Quality
					Use-as-is	1	Therm	oforming	Finishing		Rec/Stor	e/Packaging	3	Other
NCR N	No				Work Order Update			Large Fab	Composite			Supplie	r	
Root				Descri	ption of work order update	П	Initial	Acti	on	T	Sign &			
Cause	Dat	e Step	Qty	(or Non-conformance	Ch	nief Eng	Descri	ption	4	Date	Verification	on	QC Inspector
Doc/Data														
Equip/Tooling														
Operator														
Material														
Setup			1											
Other														
Process			1											
Supplier														
Training				5										
Unapproved														
					F	AUL	T CATE	GORY						
Landi	ng Gear			_	General	_	1			_				
	Bend	ng			Bend		Grain		_	\rightarrow	Ovalized			Pressure/Forced
	Centr	e Not Conce	entric to	O/S	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
	Crack	S			Broken/Damaged		Inspecti	on Incomplete			Part Incorred	ct		Weld
	Crush	ed/Crimped	i,		Burrs		Instruct	ions Incomplete/U	nclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance			Part Moved			
	Heat	Treat			Countersink		Mislabe	led			Positioned V	Vrong		
Inspection Strip in Tube Cut Too Short Misread								Power Loss/	Surge		Other			
	Dinal	os in Bond		Drill Holos Offset										

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Work Order ID 96191

Hand Finishing

96191

Page 2

January-24-13 7:59:05 AM Item ID: D2360 Accept *N900040100* Setup Start Revision ID: Stop Litter Tie Down Assembly Item Name: *4* Start Qty: 4.00 Start Date: 1/21/13 Cust Item ID: Required Date: 2/06/13 Reg'd Qty: 4.00 *4* Customer: Reference: Run Process Plan: Tooling: Approvals: Date: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Reject Set Up/ Tool ID Tool # Plan Accept Reject Insp. Work Center ID Description Code Qty Qty Number Stamp **Run Hours** QC2- Inspect parts off machine FAI/FAIB 0.00 120 *120* 10 JFC 13/02/22 JFC 12/02-23 0.00 OC Memo Quality Control 130 QC8-Inspect parts - second check 0.00 29 3.2.25 *130* QC 0.00 Memo Quality Control 140 Chemical Conversion Coat per QSI005 4.1 0.00 10 7BB226 *140* HandFinish 0.00 Memo

										DQA:	Date:	n.
NCR: Y	es / No				WORK ORDER NON-	CON	IFORM <i>i</i>	INCE / UPD	DATE	QA Closed	Date:	8 4
Work Orde	r.				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	0			1	Rework Scrap Use-as-is Work Order Update		Ma Thermot	id-tube chining corming rge Fab	Crosstube Small Fab Finishing Composite	→	Water Jet od. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	I	nitial	Acti	on	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
				La	F	AUL	T CATEGO	RY				
Landin	Bending Centre N Cracks Crushed/ Cuffs Heat Tread Inspection Ripples in	Crimped at n Strip in)/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes				inclear	Ovalized Over/Under Part Incorre Part Lost/N Part Moved Positioned Power Loss	ect lissing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 96191 *96191* Page 3 January-24-13 7:59:05 AM D2360 Item ID: Accept *N900040100* Setup Start Revision ID: distant. Litter Tie Down Assembly Item Name: *4* 1/21/13 Start Qty: 4.00 Start Date: Cust Item ID: Req'd Qty: 4.00 Required Date: 2/06/13 Customer: Reference: Start Run Approvals: Process Plan: Tooling: Date: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Work Center ID Number Stamp Description Qty **Run Hours** Code Qty White Gloss(Ref: 4.3.5.1) per QSI005 4.3-Alum 150 0.00 *150* Powdercoat 0.00 Memo START TIME: Powder Coating OVEN TEMPERAT FINISH TIME: 160 QC3-Inspect Part Finish 0.00 10X *160* QC 0.00 Memo Quality Control 0.00 170 Small Fab *170* Small Fab Assemble as per dwg D2360 Small Fab

NCR: Y	es / N	0			WORK ORDER NON-	100	VFORN	ANCE / UPE	DATE					
											QA Closed:	D	ate:	
Work Orde	er.				DISPOSITION				AGAINST D	DEI	PARTMENT	/PROCESS		
Part N	lo				Rework Scrap Use-as-is Work Order Update		N Therm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite			Water Je d. Eng. Coor re/Packaging Supplie	3	Engineering Quality Other
Root Cause	Dat	Step	Qty		otion of work order update		nitial nief Eng	Act Descr			Sign & Date	Verificati	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
					10	AUL	T CATE	GORY						
Landir	Cracks Crusho Cuffs Heat T Inspec	Not Conce	n Tube	s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instructi Mainte Mislabe Misread Offset	on Incomplete ons Incomplete/L nance led	Inclear		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 96191

96191

Page 4

January-24-13 7:59:05 AM

Required Date: 2/06/13

Item ID:

D2360

Accept

N900040100

Setup Start

Revision ID:

Item Name:

Litter Tie Down Assembly

Start Date:

1/21/13

Start Qty: 4.00 Reg'd Qty: 4.00 *4* *4*

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: Date: Tooling:

SPC (Y/N):

Date:

Run

Start

Date:

Stop

Stop

NR2

Sequence ID/ Work Center ID

Operation Description

QC:

Set Up/ **Run Hours** Tool ID

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

180

180

OC

Memo

0.00 OAS

13/04/27

Quality Control

190

Identify as per dwg & Stock Location

QC5- Inspect part completeness to step on W/O

190

Packaging Packaging

Memo

0.00

200

200

OC Quality Control QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

15-4-23. 13/4/c h 1324.23

										DQA:	Date	::
NCR:	res / No				WORK ORDER NON-	100	NFORM	AANCE / UPD	DATE	QA Closed:	Date	2.
									A TOTAL WALLEST WAY TO SHOULD AN EAST			
Work Orde	ere				DISPOSITION		1		AGAINST DE	PARTMENT,	PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		Initial	Acti	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						1						
Operator			1 1									
Material												
Setup			- €								1	
Other												
Process												
Supplier												
Training												
Unapproved												
					F	AUI	LT CATE	GORY				
Landi	ng Gear				General				_		-	70
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (D/S	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete)	Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tre	at			Countersink		Mislabe	led		Positioned \	Vrong _	
	Inspection	on Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
	Ripples i	n Bend			Drill Holes		Offset		A			

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

January-24-13 7:59:03 AM

Work Order ID:

96191

Parent Item:

D2360

Parent Item Name:

Litter Tie Down Assembly

Comments:

IPP rev H 07.06.12 ecn 825 EC

Start Date: 1/21/13

Required Date: 2/06/13

Start Qty: 4.00

Required Qty: 4.00

Comments:	IPP rev H 07.06.12	ech 825 EC											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status /
AN526C1032R18 Screw		Purchased	No			170	Each	593.0000	1	4	1/3	104/	22
				Location		Loc Qty	Le	oc Code		/	/	/	
				FP001		93				/	M 101	1158	(3x)
				452	3	93			-		N 101	4) 0	
				ST346		500			-	2			
					079	400			- 3	4 3	0	1	/
A	***************************************			110	099	100	-	0.0000			1/1	/	/
AN960JD10	NAS1149D0363J	Purchased	No			170	Each	0.0000	2	8	1	3/04/	22,
Washer AN960JD10L	4D NAS1149D0332J	M124392	(10			170	Each	0.0000	8	20	101	1	/
Washer		Purchased	7	MIZE	206	7	Laci	0.0000	9	3/6	25/	3/0	1/22
D2002-015	40 MI	Manufactured	No	M125	268 (3	170	Each	0.0000	2	8	10	1	11
Knob		Manufactured				B	9824	1112	X))	/	5	13/	2/120
D2345		Manufactured	No			170	Each	21,0000	1	4	10	1	/
Lock Channel		, , and a car ca								/	6	13/	04 6
				Location		Loc Qty	L	oc Code			/	/	/
				GA		21				. /			
				863	49	21			(0	0		1 1
D2366		Manufactured	No			170	Each	22.0000	2	8	111	- /	/ /
Lock Handle										(100	5/0	4/00
				Location		Loc Qty	L	oc Code			/		/
				ST009		22			-	1			
				863	351	3				~			
				891	61	19			10				

January-24-13 7:59:04 AM

Work Order ID:	96191									
Parent Item:	D2360							Start	Date: 1/21/13	Required Date: 2/06/13
Parent Item Name:	Litter Tie Down A	ssembly						Start	Qty: 4.00	Required Oty: 4.00
D2367 Handle Knob		Manufactured	No			170	Each	13.0000	1	1 S/04/22
				Location		Loc Qty		Loc Code		
				ST009		13				7057116
				83541		1			- 7	_ D73 +/1(3x
				89083		12				- 01 1
02372 Ouick Release		Manufactured	No			170	Each	15.0000	2	8 4 13/4/2
				Location		Loc Qty		Loc Code		120-1
				GA		15				_ B75177(5x
				86001		2			-	D978/05
			2000	92199		13		Contraction of the Contraction o	ran .	- Distord
pring		Manufactured	No			170	Each	19.0000	1	1 5/3/01/22
				Location		Loc Qty		Loc Code		
				ST009		19				
				86352		19				- 11 11
Pip Pin Assembly		Manufactured	No			170	Each	3.0000	1	\$ 13/0/p2
				Location		Loc Qty		Loc Code		1206
				GA		3				1 578455 (6
				88498		3				
06201 T" Extrusion		Manufactured	No			100	f	46.4586	1.054 4.4	4378948
				Location		Loc Qty		Loc Code		PD 13/02/15
				MAT028		46.45863153				(5 (5/52/13
				81421/		13.1586315	10			
		- 2		83987		20			-	
				89645	~ ~ ~ ~	13.3			2.0	1 0 0
				D 14643	= 834	st			3-2	end of Bates MATL NO
				~ 12457	2 = 96	208			7.5	Poila

1282

									DQA:	Date:	5
NCR: Y	es / No				WORK ORDER NON-	CONFOR	MANCE / UPI	DATE			
									QA Closed:	Date:	
Work Orde					DISPOSITION			AGAINST D	EPARTMENT	/PROCESS	
Work Orde					Rework	1 l	Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap	11	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	Ther	moforming	Finishing	-	re/Packaging	Other
NCR N	No				Work Order Update]	Large Fab	Composite		Supplier	
						1 1 22 1			C: 0		
Root			W-10000	Charles Control of the Control of th	ption of work order update	Initial	(a) each	tion	Sign &	V - 15: 11:	061
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data		1									
Equip/Tooling											
Operator							1				
Material	_										
Setup											
Other							1				
Process										1	
Supplier										1	
Training											72
Unapproved											
						AULT CAT	EGORY				
Landir	ng Gear			_	General			_	_	_	1
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to O	/S	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete/I	Unclear	Part Lost/M	issing	Wrong Stock Pulled
Cuffs Contamination Maintenance Pa					Part Moved						

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

January-24-13 7:59:04 AM

Page 3

Work Order ID:	96191								
Parent Item:	D2360						Start D	ate: 1/21/13	Required Date: 2/06/13
Parent Item Name:	Litter Tie Down Assembly						Start (Qty: 4.00	Required Qtyr 4.00
MS20470AD3-4 Rivet,Universal Head	Purchased	No			170	Each	8,602.0000	1	4 JB/04/
			Locatio	<u>n</u>	Loc Qty		Loc Code		
			GA		270				/
				15541	270			6	
			ST319		8332				
				111477	8332				_ 0 - 1
MS21042L3	Purchased	No			170	Each	7,678.0000	3	12
Nut									CD0/04/0
			Locatio	<u>n</u>	Loc Qty		Loc Code		
			FP001		3				
				122141	3				
			GA		434				
				122452	434			18	H-LT
			ST314		268				
				117885	32				
.*				119017	55				
				119075	138				
				123265	43				
			ST506		6973				
				123900	2973				1 1
				124291	4000				$ \mathcal{O}($ $)$ $)$
MS27039-1-13	Purchased	No			170	Each	568.0000	1	4 /)13/01/5
Screw									Ch 10/09/0
			Locatio	<u>n</u>	Loc Qty		Loc Code		
			GA		16				_/
				119736	16				
			ST304		52				
				119736	52			#6	26
			ST506		500				
				124326	500				

										DQA:	Date:	
NCR: Y	'es / No				WORK ORDER NON-	COI	NFORM	IANCE / UPDATE	E	QA Closed:	Date:	
				_								
Work Orde	r.				DISPOSITION	1		A	GAINST DE	PARTMENT	/PROCESS	
Work orde					Rework	7	5	Skid-tube Cro	osstube		Water Jet	Engineering
Part N	lo.				Scrap	1	V	Machining Sn	nall Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		100000000000000000000000000000000000000	1200 E-0100 E	inishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update]		Large Fab Cor	mposite	J,	Supplier	
Root				Descri	ption of work order update		Initial	Action		Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description	n	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling							- 1					
Operator							1					
Material												
Setup												
Other						1						
Process			1									
Supplier			1 1									
Training		1	1 1									
Unapproved												
					F	AUI	LT CATE	GORY				
Landin	ng Gear				General	_						
[Bending				Bend		Grain			Ovalized	_	Pressure/Forced
	Centre N	ot Conce	ntric to O/	'S	BOM/Route		Hardwa	re	_	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs		Instructi	ons Incomplete/Unclea	ar	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tre	at			Countersink		Mislabe	led		Positioned \	Wrong	_
	Inspectio	n Strip in	Tube	1	Cut Too Short		Misread		L.	Power Loss,	/Surge	Other
					Drill Holes	oles Offset						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

January-24-13 7:59:04 AM

Page 4

Work Order ID:	96191				
Parent Item:	D2360			Start Date: 1/21/13	Required Date: 2/06/13
Parent Item Name:	Litter Tie Down Assembly			Start Qty: 4.00	Required Ory: 4.00
MS27039-1-15 Screw	Purchased	No	170 Each 1,	078.0000 2 8	2/3/01/22
		Location	Loc Qty Loc Co	ode	
		ST305	78		
		123352	78		
		ST506	1000		2
		124326	1000	20 10	011
NAS679A3W	Purchased	No	170 Each 18	34.0000 1 4	F/(2/N/22
Nut				(13/4/20
		Location	Loc Qty Loc Co	ode	// / //
		GA	5		
		1463	5		
		2409	179	6	

NCR: Y	es / No				WORK ORDER NON-	CON	FORN	ANCE / UPD	ATE	=	400			
										QA Closed:	Date:			
Work Orde	. Pro				DISPOSITION				AGAINST DI	EPARTMENT/	PROCESS			
Part N	lo				Rework Scrap Use-as-is Work Order Update		N Therm	Skid-tube Machining oforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other		
Root				Descri	ption of work order update	In	itial	Acti	on	Sign &				
Cause	Date	Step	Qty	(or Non-conformance	Chie	ef Eng	Descri	ption	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved														
					F	AULT	CATE	GORY						
Landin	ng Gear			_	General					7		1		
	Bending Centre N	at Canaa	nteis to (7/s	Bend BOM/Route	\mathbf{H}	Grain Hardwa	70	-	Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure		
1	Cracks	ot Conce	ntric to t	1/5	Broken/Damaged	\vdash		on Incomplete		Part Incorrec		Weld		
	Crushed/	Crimped			Burrs	1	nstructi	ions Incomplete/U	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
Cuffs Contamination Maintenance Part Moved														
	Heat Trea	at			Countersink		Mislabe	led		Positioned Wrong				
	Inspectio		Tube		Cut Too Short	1	Misread			Power Loss/	Power Loss/Surge Other			

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

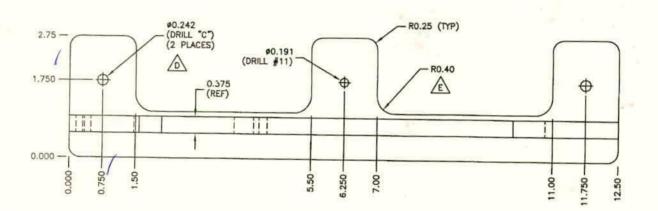
Drawing

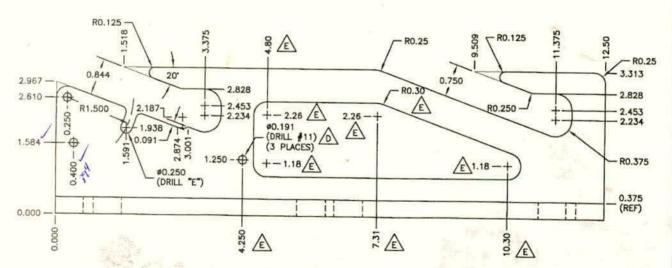
H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



DESIGN	1 50	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKE	APPROVED H	D2341 REV. F D2341 SHEET 1 OF 1
07.06	5.07	LITTER TIE DOWN BRACKET (LOCKING) 1:2
A	95.01.13	NEW ISSUE
В	95.02.14	MODIFIED LOCK
D	95.02.20	CHANGES TO DIAMETERS
E	97.10.01	CHANGES FOR MACHINING
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE









- D2341 LITTER TE DOWN BRACKET (LOCKNO)

 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION
 (6061-T6/T651 PER QQ-A-200/B)

 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010

 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



RELEASED



DESIG	BW CB		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHEC	E	APPROVED	DRAWING NO. REV. D D2360 SHEET 1 OF 2		
07.0	06.06		TITLE SCALE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS		
Α		95.02.10	NEW ISSUE		
В		95.02.20	RE-DESIGN		
С		97.08.27	ADD MS20470AD3-4 RIVET		
D		07.06.06	.06.06 D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)		

RELEASED

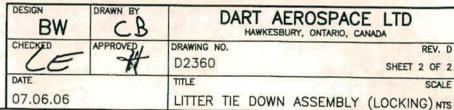
PARTS LIST:

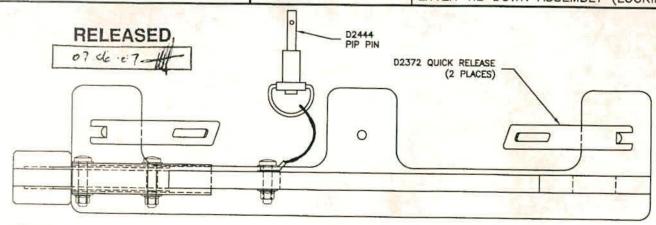
X 1	D2360	LITTED TIE DOLLEY LACE TO THE TOTAL
1		LITTER TIE DOWN ASSEMBLY (LOCKING)
	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

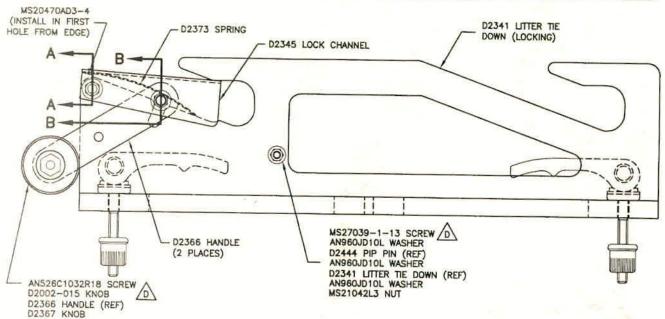


D2366 HANDLE (REF)

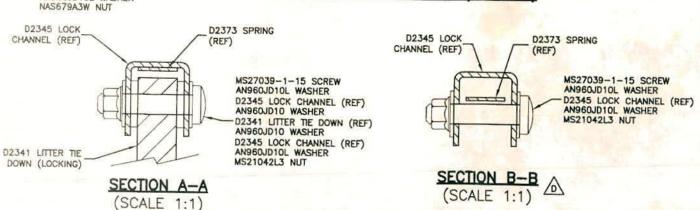
D2002-015 KNOB AN960JD10L WASHER







D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)



Copyright @ 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD	Work Order:	96191
Description: Litter Tie Down Bracket (Locking)	Part Number:	D2341
Inspection Dwg: D2341 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.742	7		FK-04	Vern
2.75	+/-0.030	2.752	7		t)	h
Ø0.242	+0.005/-0.001	.242	7		/N	P P
Ø0.191	+0.005/-0.001	.191	7		. W.	h
R0.25	+/-0.030	.25	7		- jr	h.
R0.40	+/-0.030	.40	7		()	10
12.50	+/-0.030	12.750	7		# Ft-05	Tape.
11.750	+/-0.010	11.750	7		CNC-02	Vern -
11.00	+/-0.030	11.00	7	· ·	FK-05	Tapa
7.00	+/-0.030	7,00	~		CNC-08	Vern -
6.250	+/-0.010	6.75	7		di	10-2
5.50	+/-0.030	5.50	7		fx -	1)
1.50	+/-0.030	1.50	7		FK-OU	Venn-
0.750	+/-0.010	.752	7		6.	71
0.400	+/-0.010	. 399	V		4	14
1.584	+/-0.010	1.584	7		19	e/
2.610	+/-0.010	2.610	~		18	IV.
0.250	+/-0.010	. 249	7		h	1,
0.844	+/-0.010	.842	7		()	- 1
Ø0.250	+/-0.010	.249	7		N.	1/2
0.750	+/-0.010	.750	1			N
3.313	+/-0.010	3.312	V		- 17	6
4.250	+/-0.010	4.250	>		11	K
1.250	+/-0.010	1.247	7		- J.c	

Measured by:	FK_	Audited by:	20	Prototype Approval:	N/A
Date:	13/02/22	Date:	13.2.25	Date:	N/A

Rev	Date	Change	Revised by Approve
A	06.05.24	New Issue P/O D2360	KJ/JLM
В	07.07.17	Dwg Rev. updated	KJ/JLM ,A \\
C	10.02.02	Dimensions updated	KJ W